



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Stock
7638

RB6793504-M
Job Sheet 174882



204971

Part No: RB6793504-M

Job Qty: 1 ea

Part Name: Seal Installation Kit C-30 (12 Tools)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB6793504-M Rev A IPP Rev A 18.03.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		4/28/18	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	1 pcs		4/30/18	0.00	1.00	Small Fab-4		MCC
120	QC	1 pcs		4/30/18	0.00	0.00	QC5		21 18-8-20
130	Packaging	1 pcs		4/30/18	0.00	0.00	Packaging3-1		DAS
140	QC21-FG	1 Ea		4/30/18	0.00	0.00	QC21		21 9-89

Part Op 100 -

Descriptions: 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1550 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RB6793504-M-4 to RB6793504-M-3 foam as per DWG. 6-Glue foams to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Blind Rivet	4 Ea (4 ea)	100-Start up Operation	5089128
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Start up Operation	5021040
APP-1550-E	Case	1 Ea (1 ea)	110-Small Fab	5070743
RB6793504-M-2	Bottom Foam	1 (1 ea)	110-Small Fab	5070757
RB6793504-M-3	Top Foam	1 (1 ea)	110-Small Fab	5070748
RB6793504-M-4	Content Placard	1 Ea (1 ea)	110-Small Fab	5079825
RB6796941-12	Adapter	1 Ea (1 ea)	110-Small Fab	5076462
RB6796941-14	Starter Seal Guide	1 Ea (1 ea)	110-Small Fab	5102895
RB6796941-15	Guide	1 Ea (1 ea)	110-Small Fab	50117434
RB6796941-201	Puller Assembly/Starter Seal Removal Tool	1 Ea (1 ea)	110-Small Fab	50104209
RB6796941-203	Slide Hammer Assembly	1 Ea (1 ea)	110-Small Fab	5076864
RB6893504	Pusher Seal Installation Seal Support	1 (1 ea)	110-Small Fab	5076444
RB6893505	Pusher Seal	1 (1 ea)	110-Small Fab	5076447
RB6893506	Seal Install Tachometer Pusher	1 (1 ea)	110-Small Fab	5028432
RB6893507	Seal Install Power Turbine Pusher	1 (1 ea)	110-Small Fab	5076449
RB6893508	Seal Install Fuel Pusher	1 (1 ea)	110-Small Fab	5028434
RB6893509	Seal Install Starter Generator Support Pusher	1 (1 ea)	110-Small Fab	5076445
RB6893728	Pusher-Seal Installation Front Spare Pad	1 (1 ea)	110-Small Fab	5080518

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	97524A032	4	235	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐								
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																									
Large Fab ☐	Composite ☐	Supplier ☐																										
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																								
Description Work Order Deviation		Disposition		Completed By																								
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/13/18				Hand / Supervisor approval Verification																								
				QC / QA Coordinator Approval																								
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table> Pres Ben Cer Cra Cria Cu Crushing Heat Treat Wave/Twist in Tube Marks/Chatter OTHER :					Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐
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Past Expiry Date ☐	Manufacturing Process ☐																											
Misidentified ☐	Past Due ☐																											

110-Small Fab

RB41011	1	938	0
APP-1550-E	1	1	0
RB6793504-M-2	1	0	0
RB6793504-M-3	1	0	0
RB6793504-M-4	1	0	0
RB6796941-12	1	0	0
RB6796941-14	1	4	0
RB6796941-15	1	0	0
RB6796941-201	1	4	0
RB6796941-203	1	0	0
RB6893504	1	0	0
RB6893505	1	0	0
RB6893506	1	0	0
RB6893507	1	0	0
RB6893508	1	0	0
RB6893509	1	0	0
RB6893728	1	0	0

Part Specifications

Specifications could not be found.

Plex 3/22/18 2:40 PM Dart.lajeunesse.marie

* DQA: _____ Date: _____



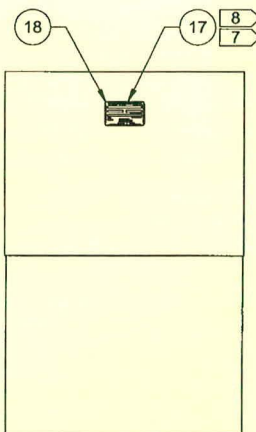
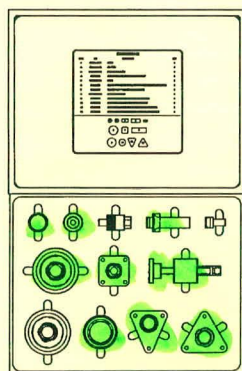
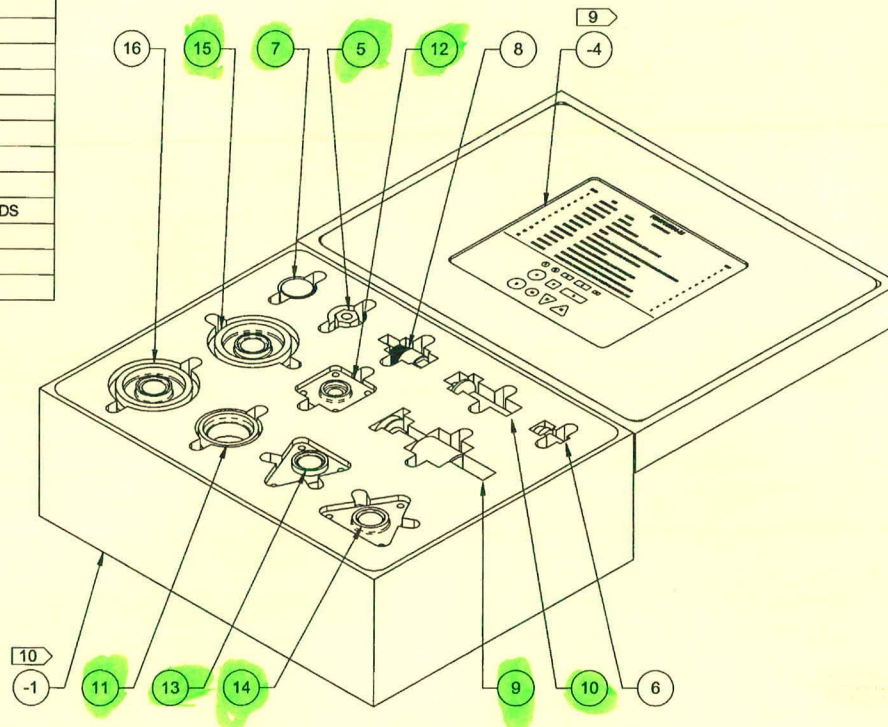
WORK ORDER NON-CONFORMANCE / UPDATE

* QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM #	QTY	PART #	PART TITLE
-1	1	RB6793504-M-1	PACKAGING ASSY
-4	1	RB6793504-M-4	CONTENT PLACARD
5	1	RB6796941-12	ADAPTER
6	1	RB6796941-14	GUIDE
7	1	RB6796941-15	GUIDE
8	1	RB6796941-201	START PULLER ASSY
9	1	RB6796941-203	SLIDE HAMMER ASSY
10	1	RB6893504	PUSHER SEAL INSTALLATION, SEAL SUPPORT
11	1	RB6893505	PUSHER-SEAL INSTALLATION, POWER TAKE OFF
12	1	RB6893506	PUSHER-SEAL INSTALLATION, TACHOMETER
13	1	RB6893507	PUSHER-SEAL INSTALLATION, POWER TURBINE GOVERNOR
14	1	RB6893508	PUSHER-SEAL INSTALLATION, FUEL PUMP/FUEL CONTROL PAD
15	1	RB6893509	PUSHER-SEAL INSTALLATION, STARTER/GENERATOR AND SPARE PADS
16	1	RB6893728	PUSHER-SEAL INSTALLATION, FRONT SPARE PAD
17	1	RB41011	DART PLACARD
18	4	McMaster#97524A032	SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE PLASTIC PLACARD ONTO THE TOP FOAM
- 10) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

RB6793504-M ENGINE SEAL KIT

A	NEW ISSUE	18-684	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 03/20/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/20/2018	TOOL PART #	REV. A
MFG. APPR.	DD 03/20/2018	RB6793504-M	SHEET 1 OF 9
APPROVED	ML 03/21/2018	TITLE	SCALE
DATE	3/21/2018	ENGINE SEAL KIT	NTS
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